

Date: Thursday, 4/26/2007 3:33:48 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : CYCLIC STICK
Job Number : 32074	
Estimate Number : 12832	
P.O. Number : N/A	Part Number : G10202
This Issue : 4/26/2007 S.O. No. : N/A	Drawing Number : G10202 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A	Drawing Revision : A
Previous Run : 31943	Material : N/A
Written By : <u>Kim Johnston</u>	Due Date : 5/18/2007
Checked & Approved By : <u>Kim Johnston</u>	Qty: 2 Um: Each
Comment : Est Rev: A New Issue 07-04-16 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304TR1125W065	304 RD Tube 1.125 x .065w
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Comment: Qty.: 2.6250 f(s)/Unit Total: 5.2500 f(s)

304 RD Tube 1.125 x .065w

Batch: 1104134

104134

2.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

Form ,Cut all 3 parts of assembly as per Dwg G10202. & DT8940

07-05-03 (1) PP

3.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

07/05/04 (1)

4.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1

Weld assembly as per dwg G10202

A/R SS Rod Batch: 1102756

07/05/07 (1)

5.0	QC5/9	WELD INSPECTION
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Comment: WELD INSPECTION

PD 0705-07 (1)

6.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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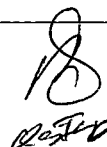
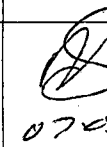
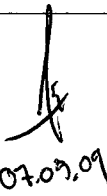
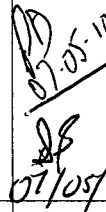


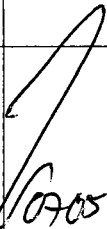
Comment: CONVENTIONAL MILLING MACHINE

Drill as per Dwg.

28 07/05/10/01

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/05/10
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
		One part assy scrap		Destroy	 050703	 050703	 050703	 070503
07.09.09	6	#12 DRILLED HOLE @ WRONG: DRILLED AT 1.00" INSTAD OF 1.25".	 07.09.09	PLUG / FILL HOLE WITH WELD AND DRILL #12 HOLE AS PER DRAWING. ENSURE NO SHARP EDGES INSIDE.	 07.05.10 07/05/10	 07/05/10	 07/05/10	 07/05/10

NOTE: Date & initial all entries

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CYCLIC STICK

Job Number: 32074

Part Number: G10202

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

En 07/05/10

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 51244

7/6/10 SG

W

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

2807/05/10

Job Completion



W 07/05/10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

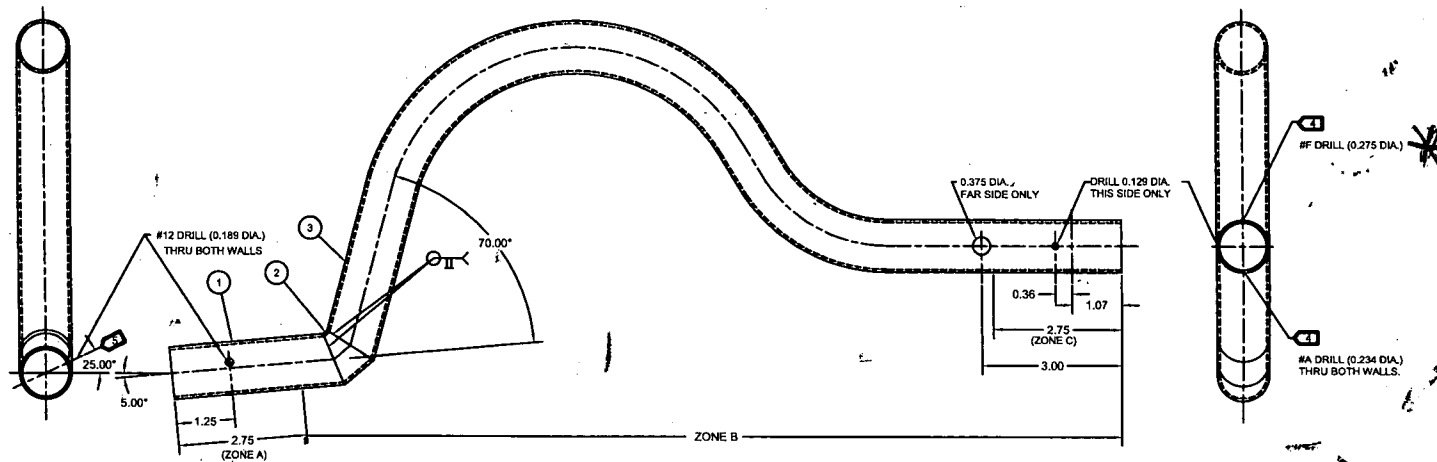
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

REVISIONS		
REV	DESCRIPTION	APPROVAL DATE
A	REDRAWN IN CAD	5/30/03 CLB



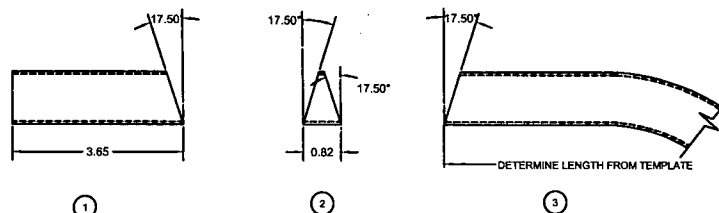
DETAIL -1

ZONE	TOLERANCE
A	±.050
B	±.300
C	±.050

NOTES: 1 DEBURR ALL SHARP EDGES.

- 1 DRILL 0.234 DIA. THRU BOTH WALLS. THEN DRILL 0.257 THRU ONE WALL AS SHOWN
- 2 DRILL 0.189 DIA. THRU BOTH WALLS. AT 25° OFF HORIZONTAL AXIS AS SHOWN.

OPTIONAL: TEXT MAY BE ENGRAVED, STAMPED OR PRINTED ON PART AS DESIRED



51'

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 32074

1	-1	1.125 O.D. ; .056 TO .070 WALL	304 STAINLESS TUBING
QTY	DASH	DESCRIPTION	MATERIAL
BREAK SHARP EDGES 125	DESIGNED CLB	DATE 5/30/03	 Geneva Aviation www.GenevaAviation.com
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	DRAWN	DATE	
TOLERANCES ARE: FRACTIONS DECIMAL ANGLES	CHECKED	DATE	
1/16" X ±.050 1/32" X ±.020 .001 X ±.010	APPROVED GLH	DATE 5/30/03	
THIS DOCUMENT INCLUDES INFORMATION PROPRIETARY TO GENEVA AVIATION AND SHALL NOT BE USED OR DUPLICATED BY ANYONE WITHOUT THE WRITTEN PERMISSION OF GENEVA AVIATION, INC.			Title CYCLIC STICK Drawing Number G10202 Pro No: GA122 Size B Scale: 1:1 Sheet 1 of 1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries